

Date: Thursday, 5/3/2007 11:38:09 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER	
Job Number	: 32196		Part Number	: D35341	
Estimate Number	: 12524		Drawing Number	: UNDER REVIEW	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 5/3/2007	S.O. No. : N/A	Drawing Revision	: 07.05.04	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 5/28/2007	
Previous Run	: 28426		Qty:	3	Um: Each
Written By	:				
Checked & Approved By	: 07.05.04				
Comment	: Est Rev:A New Issue 06-09.06 EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S050	2024-T3.050 sheet
Comment: Qty.: 0.2048 sf(s)/Unit Total : 0.6143 sf(s) 2024-T3.050 sheet Batch: M103321 ml 07 05 29		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3534 Dwg Rev: 07.05.04 U/R Prog Rev: 07.05.04 U/R		
ml 07 05 29		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
ml 07 05 29		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1		
ml 07 05 29		
Debur if necessary.		
ml 07 05 29		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 09/05/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MS

07-05-30

3

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

~~07/05/30 (3)~~

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

~~07/05/30 (3)~~

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

~~07/05/30~~

Job Completion



~~07/05/30~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

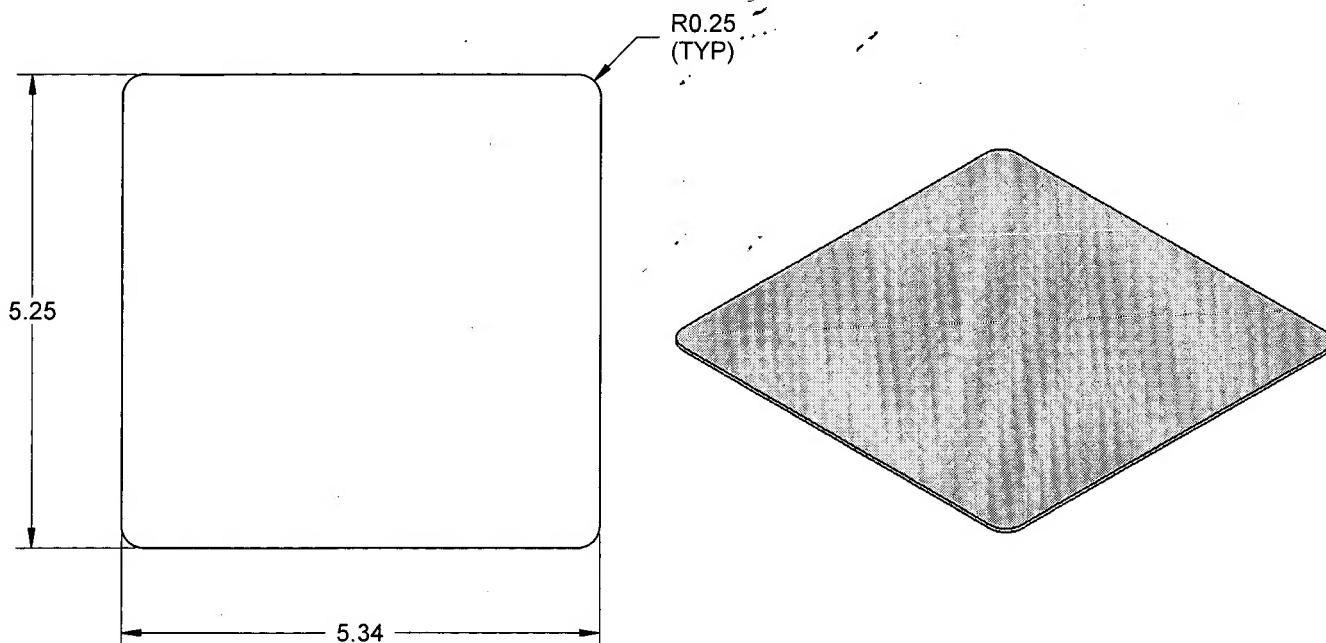
NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED PH	APPROVED	DRAWING NO. D3534
DATE	07.01.10	TITLE DOUBLER
REV A	DATE 07.01.10	DESCRIPTION NEW ISSUE

UNDER REVIEW

07.05.09 CB
dwg not released



D3534-1 DOUBLER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32196

NOTES:

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET, 0.050 THICK PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3534-1" USING FINE POINT PERMANENT INK MARKER

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DART AEROSPACE LTD

Work Order: 32196

Description: Doubler

Part Number: D3534-1

Inspection Dwg: U/R

Rev: U/R

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 5.25	+/- 0.030	5.259	✓		VERN	
B 5.34	+/- 0.030	5.348	✓		VERN	
C R0.25	+/- 0.030	R0.25	✓		Radius Gage	
D						
E						
F						
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: M. M.
Date: 07 05 29

Audited by: J
Date: 0705-29

Prototype Approval: N/A
Date: N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	